

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004516**Date Inspected:** 30-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shangxing Island, Shanghai**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Deck panel**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) representative was present for observations relative to fabrication performed by Zhenhua Port Machinery Company (ZPMC) for the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Changxing Island, in Shanghai, China.. While on site the QA Inspector noted the following:

Deck Panels

1. The QA Inspector was requested to perform Ultrasonic Testing (UT) using the gate to gate technique on the tack weld areas on the partial joint penetration welds made between the U-ribs and flat plate on the deck panel identified as DP179-001, DP352-001 and DP325-001. The QA Inspector was notified Task Leader Albert Carreon these deck panels were taken priority and that the testing needed to be complete. The QA Inspector could not locate the deck panel DP179-001 and requested ZPMC Quality Control personnel to provide the QA Inspector with information regarding the location of the mentioned deck panel. The ZPMC Quality Control personnel notified QA Inspector the deck panel was located outside of facility and was not accessible to perform any testing as of this time. The QA Inspector notified Task Leader Albert Carreon of none availability testing for the requested deck panel. At the time of arrival at the location to perform the UT on the deck panel DP352-001 and DP325-001 the QA Inspector observed the ZPMC welding personnel were in process of performing base material preparation prior to fit up the two mentioned deck panels. The ZPMC personnel notified QA Inspector the deck panels will not be accessible for UT until later notification.

Deck Panel DP324-002

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

2. The QA Inspector performed Ultrasonic Testing (UT) on the partial joint penetration welds made between the U-ribs (four ribs two welds per rib eight total welds) and flat plate on the assembly deck panel identified as DP324-002. The QA Inspector performed the ultrasonic testing using the gate to gate technique on the tack weld areas only a total of 224 tack welds were made on the eight welds. The QA Inspector performed the testing on the weld number one through six. During the in process testing at the time the QA Inspector took time off for dinner (lunch) the ZPMC personnel picked up the deck panel and placed it on the dooly. The QA inspector requested the ZPMC personnel to place the deck panel back in the ground so the QA Inspector could continue the testing. Later during the shift the ZPMC personnel placed the deck panel back in the ground and the QA Inspector continued the testing. The QA Inspector observed several linear indications at random locations and the indications were marked on the steel for phased array ultrasonic testing investigation that will be performed at a later time. The QA Inspector completed the testing on these welds at this location on this date. The QA Inspector recorded the indication's location observed on the QA Inspector's log and is available for review as requested. The QA Inspector notified Task Leader Albert Carreon of incident occurred during testing, of indications observed and the status of the testing.

Summary of Conversations:

As noted within the body of the report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann, (1500) 129-9593, who represents the Office of Structural Materials for your project.

Inspected By:	Medina,Ricardo	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
